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TEST REPORT

Diameters (Cl. No 6.3.1)

Requirement: The nominal size and minimum mean inside diameter for DN/ID

Nominal size (inside diameter)	Minimum Mean (inside diameter)
300 mm	294 mm

Specimen No	Observation	Result
	Inside Diameter	
1	295.00 mm	Pass
2	294.50 mm	Pass
3	295.00 mm	Pass
4	294.50 mm	Pass
5	295.00 mm	Pass
6	295.00 mm	Pass
7	295.00 mm	Pass
8	294.00 mm	Pass
9	295.50 mm	Pass
10	294.50 mm	Pass
11	295.00 mm	Pass
12	295.00 mm	Pass
13	294.50 mm	Pass

Wall Thickness (as per table 1)

Requirement : minimum wall thickness conforming table 5

E4 Min	E5 min
2.0 mm	1.7 mm

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Specimen No	Observation		Result
	E4 Min	E5 Min	
1	2.75 mm	2.05 mm	Pass
2	2.78 mm	2.05 mm	Pass
3	2.75 mm	2.08 mm	Pass
4	2.80 mm	2.08 mm	Pass
5	2.85 mm	2.10 mm	Pass
6	2.78 mm	2.15 mm	Pass
7	2.78 mm	2.28 mm	Pass
8	2.72 mm	2.05 mm	Pass
9	2.84 mm	2.08 mm	Pass
10	2.78 mm	2.08 mm	Pass
11	2.80 mm	2.10 mm	Pass
12	2.78 mm	2.05 mm	Pass
13	2.80 mm	2.05 mm	Pass

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Resistance to Heating Oven Test

Requirement: The Pipe Shall No Delamination Cracks or Bubbles at (110+2) Degrees Celsius for e< 8mm for 30 minutes & e>8mm for 60 Minutes

Specimen No.	Observation	Result
1	No Delamination Cracks Or Bubbles	Pass
2	No Delamination Cracks Or Bubbles	Pass

Dimension of Pipes
(clauseno 6.3.2. length)

Requirement The Effective Length of the Pipe Shall Not Be Less Than That Specified by The Manufacture (5.95 Mtrs)

SPECIMEN NO	OBSERVTION	RESULT
1 to 13 pipes	6.00 meters to 6.010 meters	PASS

(clause 6.3.5.1.1) socket length

Requirement : 64.00 mm

Specimen no	Observation	Result
13 pipes	140.90 mm	pass

F. Mechanical characteristics of Pipes:(Cl. No 8.1

Ring Stiffness(As Per Table 10)

Requirement: > relevant SN

Specimen No.	Observation	Relevant SN	Result
1	8.89 KN/m2	SN 8	PASS

Ring Flexibility 30 (As Per Table 10)

Requirement During the Test at 30% Deflection of Dem, There Shall Be No Decrease of Measured Force & No Cracking in Any Part of Wall Structure. After The Test There Shall Be No Wall Delamination Expected Possible Delamination Between the Outside &Inside Wall of Double Wall Pipes Occurring in Reduced Welding Zone at The End of Test Piece. No Other Types of Rupture in The Test Piece Permanent Buckling in Any Part of the Structure of the Pipe Wall Including Depression and Craters Shall Not Occur in Any Direction.

Specimen No.	Observation	Result
1	No decrease of Measure force & no Cracking in any part of the wall structure. There is no wall delamination between outside & inside wall of Double Wall Pipe. No other types of rupture in the test piece & no permanent buckling in any part of the structure of the pipe.	Pass

Impact Strength at 0 Degree Celsius.
(As Per Table 10)

Requirement:

TIR	<10 Percent
Test Temperature	(0+1) Degree Celsius for 30 min
Type Of Striker	D 90
Mass Of Striker	2.5 KG
Fall Height Of Striker	2000 mm

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